

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017954**Date Inspected:** 12-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fa Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#12

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SA3114D-026-006)

-(SA3114D-027-006)

-(SA3114D-028-006)

-(SA3114D-030-006)

-(SA3114D-031-006)

-(SA3114D-032-006)

-(SA3114D-008-006)

-(SA3114D-009-006)

-(SA3114D-010-006)

-(SA3114D-033-006)

Green Tag issued on all the above components. Green tag number is 015064

Bay#8

This QA inspector performed VT of approximately 100% of the area previously inspected and accepted by ZPMC Quality Control personnel. VT was performed on the welds and the base metal of the anchor house assembly, before welding of the closure plate. The member is identified as Bike Path Components. The weld designations

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reviewed are as follows:

- (BK004A3-056-065, 067, 068, 100, 101, 102, 069, 070, 071, 103, 104, 105)
- (BK004A4-056-080, 082, 083, 100, 101, 102, 085, 086, 087, 103, 104, 105)

Material storage yard.

This QA inspector witnessed the check/cut samples for destructive test. The material grade is A709M-345F2-X. The check samples were cut for the destructive test for the fracture critical Plates. The heat number and thickness of the plates are as below:

1. Heat#10402783N2 Thickness-35 mm

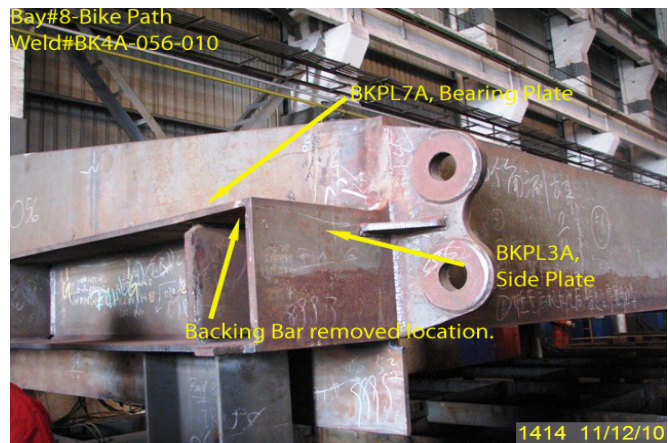
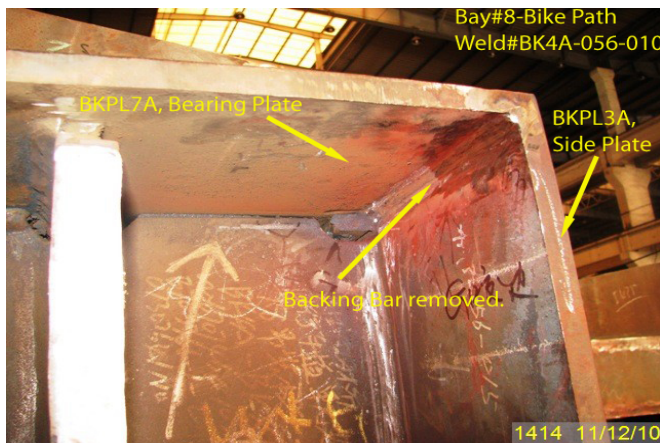
Bay#8

During random in process visual inspection of the bike path component, this QA inspector observed the following issue;

- ZPMC personnel was removed the steel backing bar from the CJP weld.
- According to the Weld Detail drawing, this weld is CJP with steel backing bar.
- After complete welding of this weld with steel backing bar, CT QA inspector observed the excessive root opening between steel backing bar and the base plate. (For more information, please review the incident report#1648, generated on 10/28/2010)
- The steel backing bar was removed by carbon arc gouging from the area having a more root opening (more than 6mm).

For further information, please find attached Pictures.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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